

Work Order ID 80909

80909

Page 1

March-05-12 10:19:50 AM

Item ID: D3389-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Web
 Start Date: 05/03/2012 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 19/03/2012 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/05 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3389	Rev D

100 Skidtubes 0.00

100

Skidtubes

Skidtubes

Memo

- 1- Pick D2500-3-100
- 2- Deburr
- 3- Locating from deburred end, drill pilot holes using DT8785 as per dwg D3389. Scribe cut line.
- 4- Cut to finished length
- 5- Open holes to finished size as per dwg D3389
- 6- Deburr

110 QC6- Inspect dimensions to drawing 0.00

110

QC

Quality Control

Memo

0.00

(10) NG 12-3-6

BB

12/03/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							(10) 12-3-6
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							DP 12-3-6
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: 46 Memo	0.00 0.00							DP 12-3-6

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March-05-12 10:19:50 AM

Item ID: D3389-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Web

Stop *NS2*

Start Date: 05/03/2012 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 19/03/2012 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject Qty

Reject Number

**Insp.
Stamp**

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/3/79

112-63-

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

March-05-12 10:19:55 AM

Page 1

Work Order ID: 80909

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Parent Item: D3389-1

D3389-1

Parent Item Name: Web

Start Date: 05/03/2012

Required Date: 19/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A05.08.31New issueKJ/JLM

IPP Rev:B 06-02-08 As per Rev C JLM

IPP Rev:C 07-11-13 ECN 1056 Rev D dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			100	Each	84.0000	1	10			

D2500-3-100

Ext'n - I' Beam Web 4"

**
⑩ 12-3-6

Location

Loc Qty

Loc Code

LG

84

51957

2

66298

13

79041

69

10

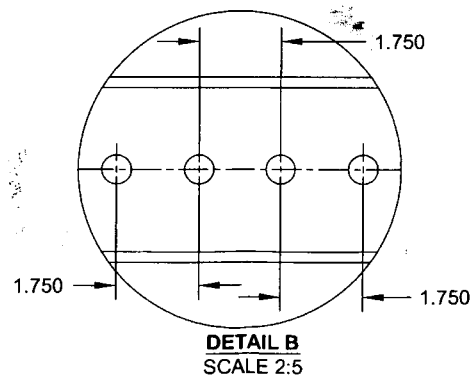
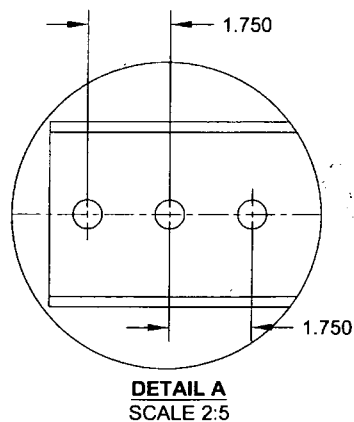
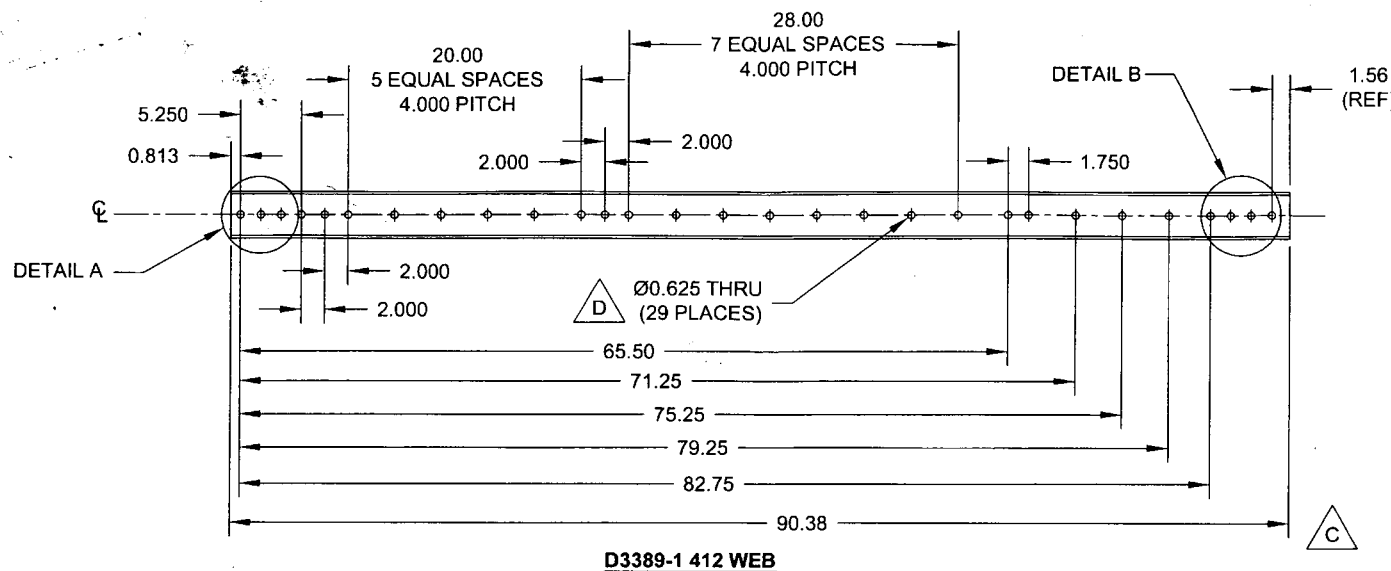
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NOTES:

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.6 lbs

RELEASED
07.11.06 MJD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 80909 MJS
12/03/05

D	REVISE HOLE DIAMETER FROM Ø0.257 TO Ø0.625, ZONE D4; REFORMAT DRAWING	PH	07.10.09
C	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
B	UPDATE DIMENSIONING	PH	05.06.13
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	pd	DART AEROSPACE USA, INC	
DRAWN	RA	PORT HADLOCK, WA	
CHECKED	1	DRAWING NO.	REV 10
MFG. APPR.		D3389	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		412 WEB	1:1
DATE	07.10.09	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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